

ASAP Please

Work Order ID 69079

Thursday, April 28, 2011 12:31:37 PM

Ship May 3 if possible



Item ID: D2975

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/28/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2975	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2975 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

11-4-09

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-4-09

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/16/02

(42)

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Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Deburr if necessary Form as per dwg D2975 using DT8261 & DT8326

SB 11/6/02

12

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

S 11/6/02

12

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT8210 as per Dwg D2975 & QSI 004 Qty

Description

Batch LIA/R 7560 Hardcoat Rod 11/7/09

EL 11-5-2 12

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 u105/03

412

170 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M115128

Memo

0.00

Powder Coating

START TIME:

11:40

OVEN TEMPERATURE:

320° FINISH TIME:

12:10

12 Bl 11-5-3

180 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12-4 Ju u105/03

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Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 497A

0.00



Packaging

Memo

0.00

Packaging

11/5/38/ (120)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/38/

MF
11-05-03

Picklist Print

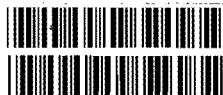
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Page 1

Work Order ID: 69079

Parent Item: D2975

Parent Item Name: Wearshoe





Start Date: 4/28/2011

Required Date: 5/3/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: C02.10.23 Re-format KJL
IPP Rev:D Now on Waterjet 06-11-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 		Purchased	No			100	sf	166.0000	0.2758	1.451579	3.5		
											B11-4-28		

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

166

116791

38

117500

128

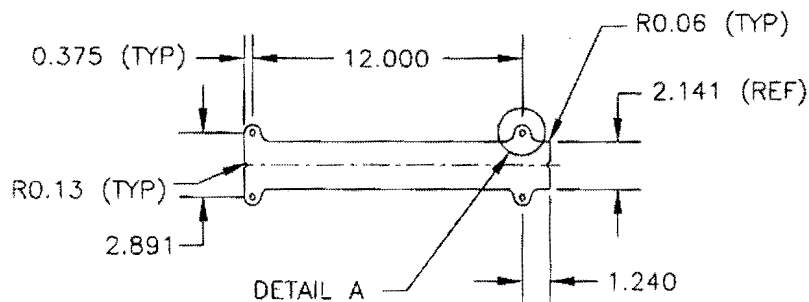
116791

12

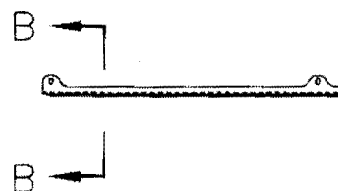


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2975	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE WEARPLATE	SCALE 1:8
A	00.03.10	NEW ISSUE	

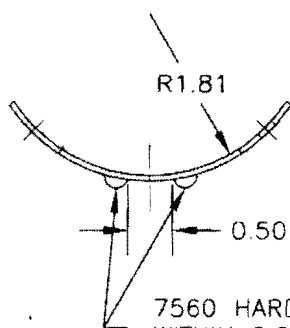
FLAT PATTERN



BENDING DETAIL

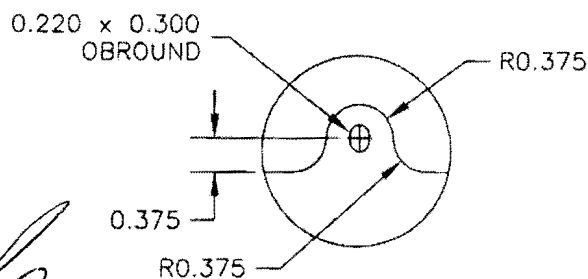


SECTION B-B SCALE 2:5



7560 HARDCOAT WELDS TO
WITHIN 0.25 OF WEARSHOE
ENDS 0.063 TO 0.125 THICK

DETAIL A SCALE 2:5



RELEASED
00.05.10 *[Signature]*

BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
16 GAUGE (0.063 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF: 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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